

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03266				SHEET 1 OF 2	
	DWG NO. 647.9000	REV: N/C	PREPARED BY A. QUAN	DATE: 11/15/11	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: SHEETMETAL					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER AND STOCK		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED 647.9014 MATERIAL, REVISED DIMENSIONS OF P/N 647.9012					

SHEET 1, NOTES:

NOTES: UNLESS OTHERWISE SPECIFIED

- 1

MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 2

FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N
- 3

DEBURR AND BREAK ALL SHARP EDGES
- 4

IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12PT. CENTURY GOTHIC.
- 5

ALL DIMENSIONS SHOWN PRIOR TO FINISH.
- 6

PART DIMENSIONS CONTROLLED BY CAD MODEL; FILE NAME: 647.9016 DOUBLER.SLDPRT-LAST MODIFIED 06-29-10
- 7

INSPECTION DIMENSIONS SHOWN WITH FINISH APPROX. 3-5 MIL MAX PER FACE.
- 8

MATERIAL: 304SS IAW AMS 5643
- 9

FINISH: PRIME IAW MIL-P-23377J, TYPE I, CLASS N

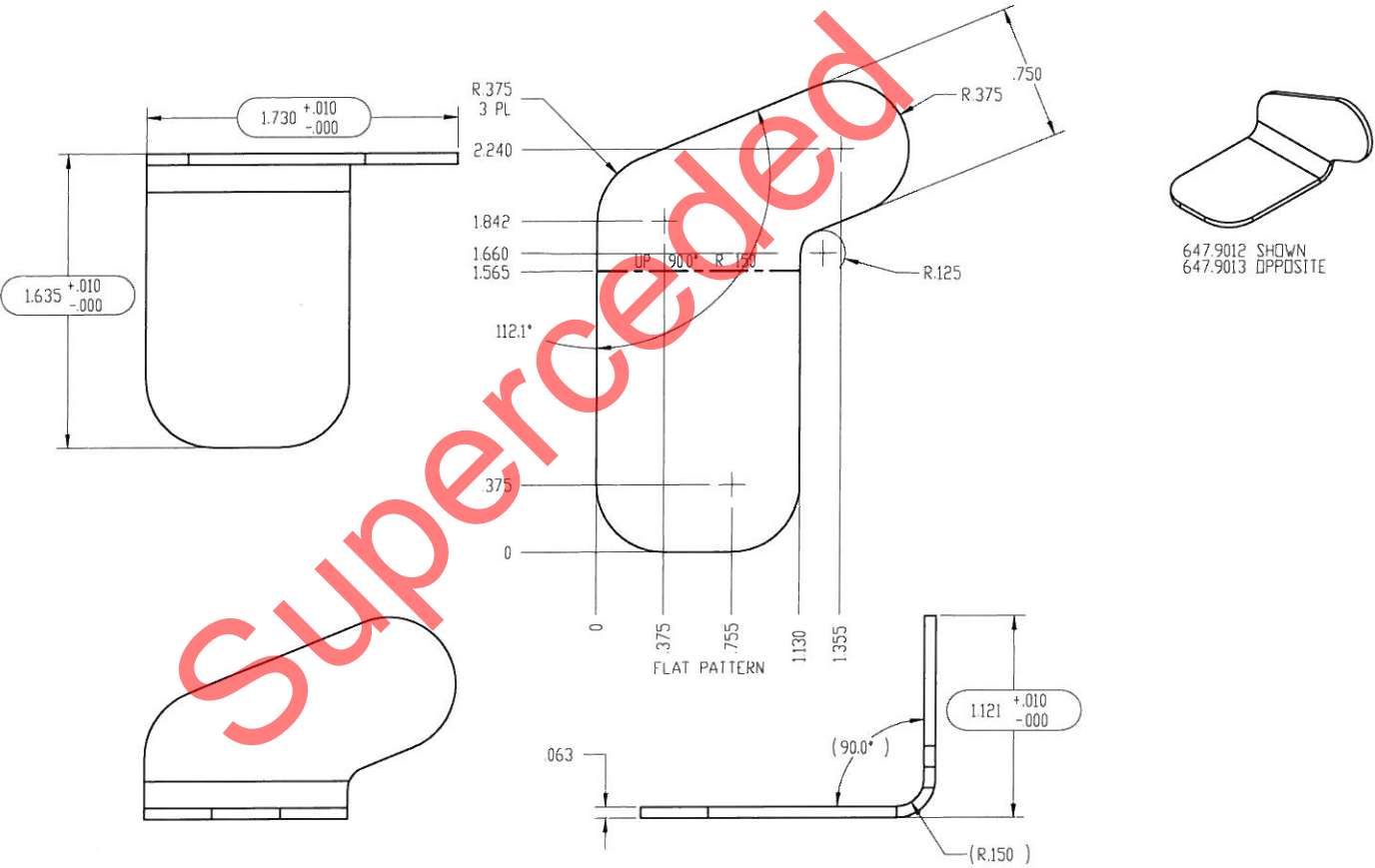
IS

5	R	647.9014		STRUT BRACKET	8	9
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03213				SHEET 1 OF 1	
	DWG NO. 647.9000	REV: N/C	PREPARED BY A. QUAN	DATE: 11/09/11	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: SHEETMETAL					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER AND STOCK		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED 647.9013 DIMENSIONS				

SHEET 3, IS:



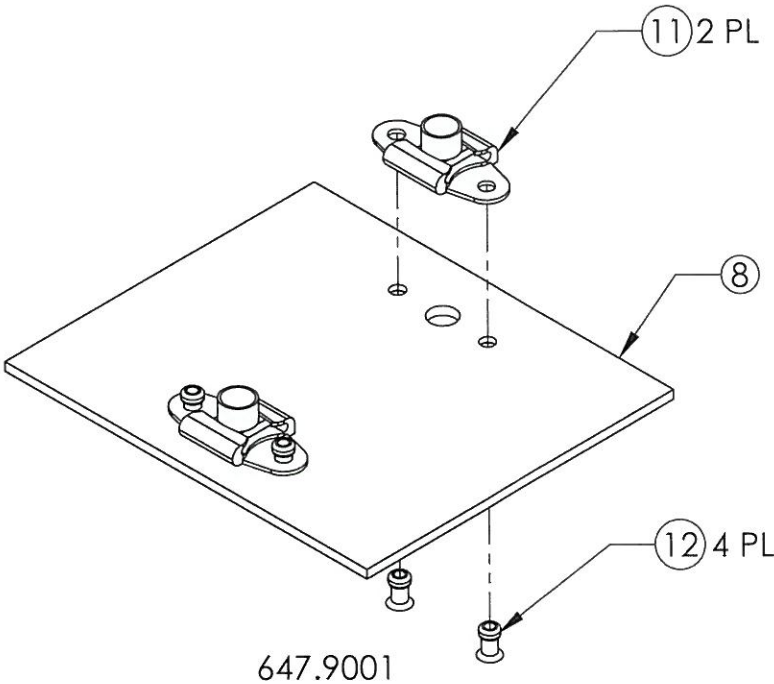
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE RELEASE: PR2		
N/C	INITIAL RELEASE	06-30-10	P. BRAVO

NOTES: UNLESS OTHERWISE SPECIFIED

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12PT. CENTURY GOTHIC.
5. ALL DIMENSIONS SHOWN PRIOR TO FINISH.
- 6 PART DIMENSIONS CONTROLLED BY CAD MODEL; FILE NAME: 647.9016 DOUBLER.SLDPR-T-LAST MODIFIED 06-29-10
7. INSPECTION DIMENSIONS SHOWN WITH FINISH APPROX. 3-5 MIL MAX PER FACE.



UNINCORPORATED ECN(s)

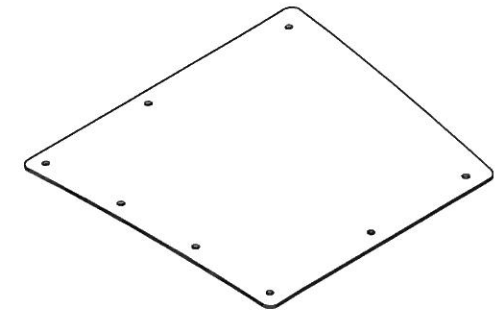
03213, 03246

	4	12	601.2277	RIVET	CCR264SS-3-02	
	2	11	601.1900	NUTPLATE	MS21059-3	
		10	647.9019	HINGE	1	2
		9	647.9018	DOUBLER	1	2
	1	8	647.9017	DOUBLER	1	2
		7	647.9016	DOUBLER	1	2, 6
		6	647.9015	DOUBLER	1	2
		5	647.9014	STRUT BRACKET	1	2
		4	647.9013	FWD CLIP	1	2
		3	647.9012	FWD CLIP	1	2
		2	647.9011	DOUBLER	1	2
		1	647.9010	DOUBLER	1	2
			647.9001	DOUBLER ASSY	1	2
	.9001	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE (MO-DA-YR) 04-13-10	
647.8900		DRAWN BY R. ROSANO CHECKER P. BRAVO	
647.9400		DRAWING APPROVAL P. BRAVO 06-30-10	
		CONTRACT No.	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ±.5°	
		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
		SHEETMETAL	
		SIZE B	CAGE CODE 07MZ6
		DWG. NO. 647.9000	REV. N/C
		SCALE NONE	
		SHEET 1 OF 9	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.9010 SHOWN
647.9011 OPPOSITE

R.250 THRU
4 PL

8.119
7.715
6.802
6.480

DOWN 6.7° R 64.945

7.010^{+0.010}
-0.000

.400
.250
0
Ø.160
8 PL

0 .250 .385 .580 2.670 3.817 4.955 7.233 7.384 7.633

.063

FLAT PATTERN

(R64.945)

7.625^{+0.010}
-0.000

ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY P. ROSANO	CHECKER P. BRAVO				
DRAWING APPROVAL P. BRAVO 06-30-10					
CONTRACT No.		SHEETMETAL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.9000	REV. N/C
		SCALE NONE		SHEET 2 OF 9	

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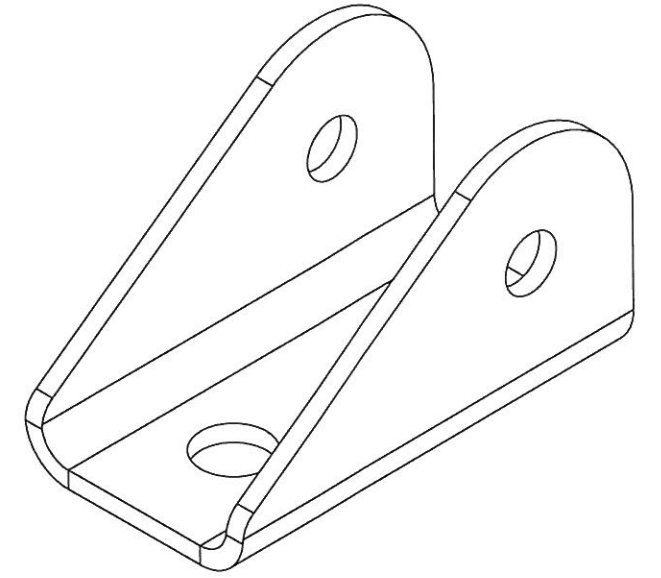
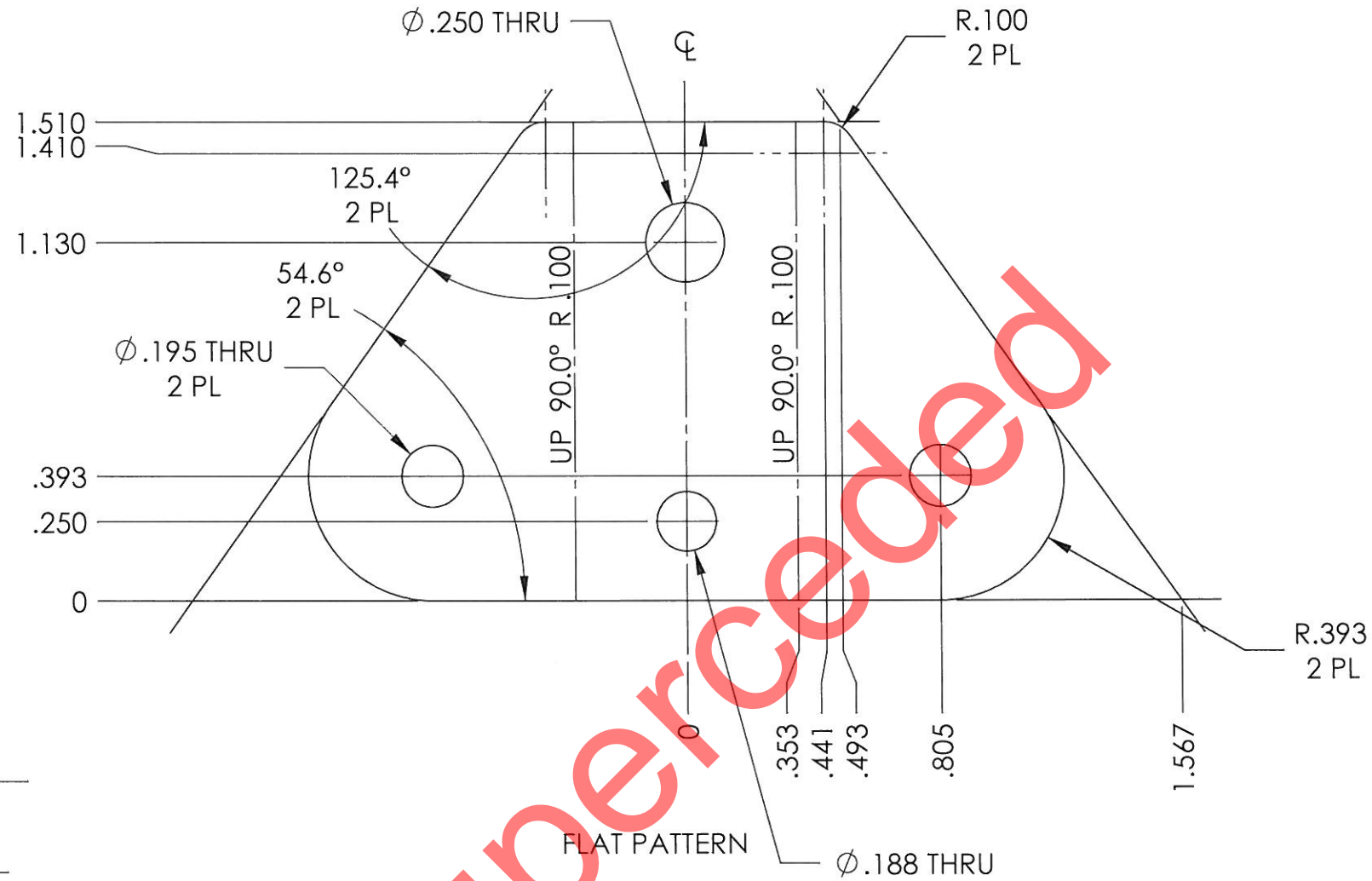
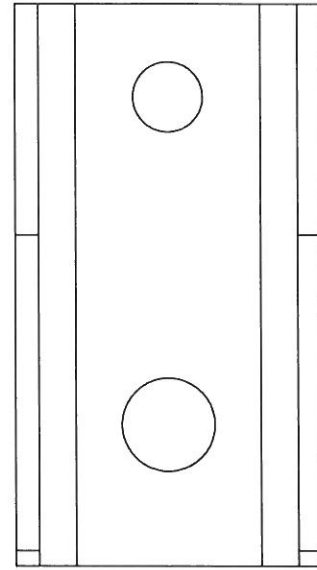
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

A

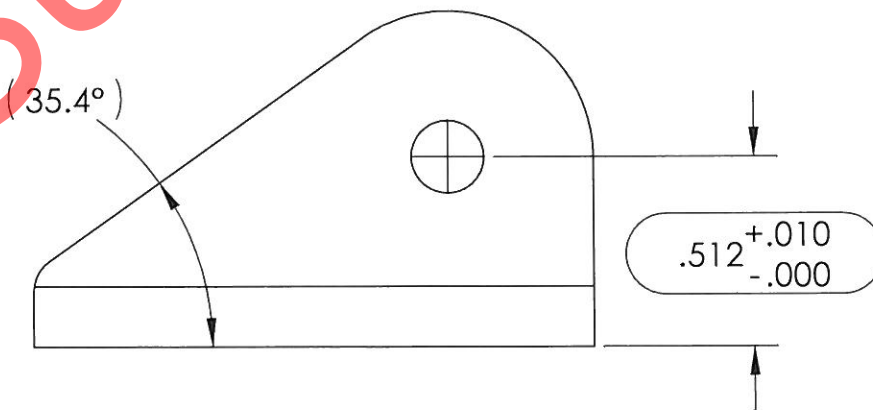
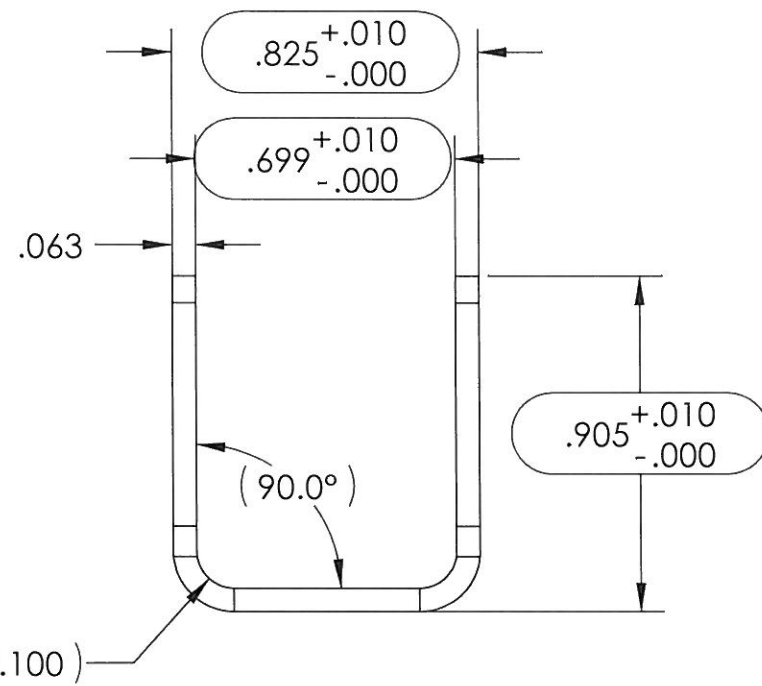
B

C

D



647.9014



ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES	
DRAWN BY R. ROSANO	CHECKER P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO 04-30-10		SHEETMETAL	
CONTRACT No.		SIZE B	REV. N/C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07MZ6	DWG. NO. 647.9000
		SCALE NONE	SHEET 4 OF 9

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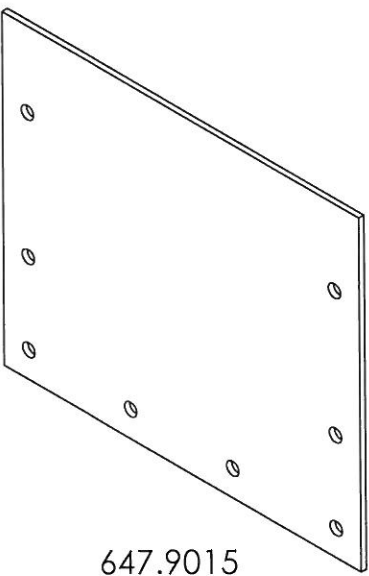
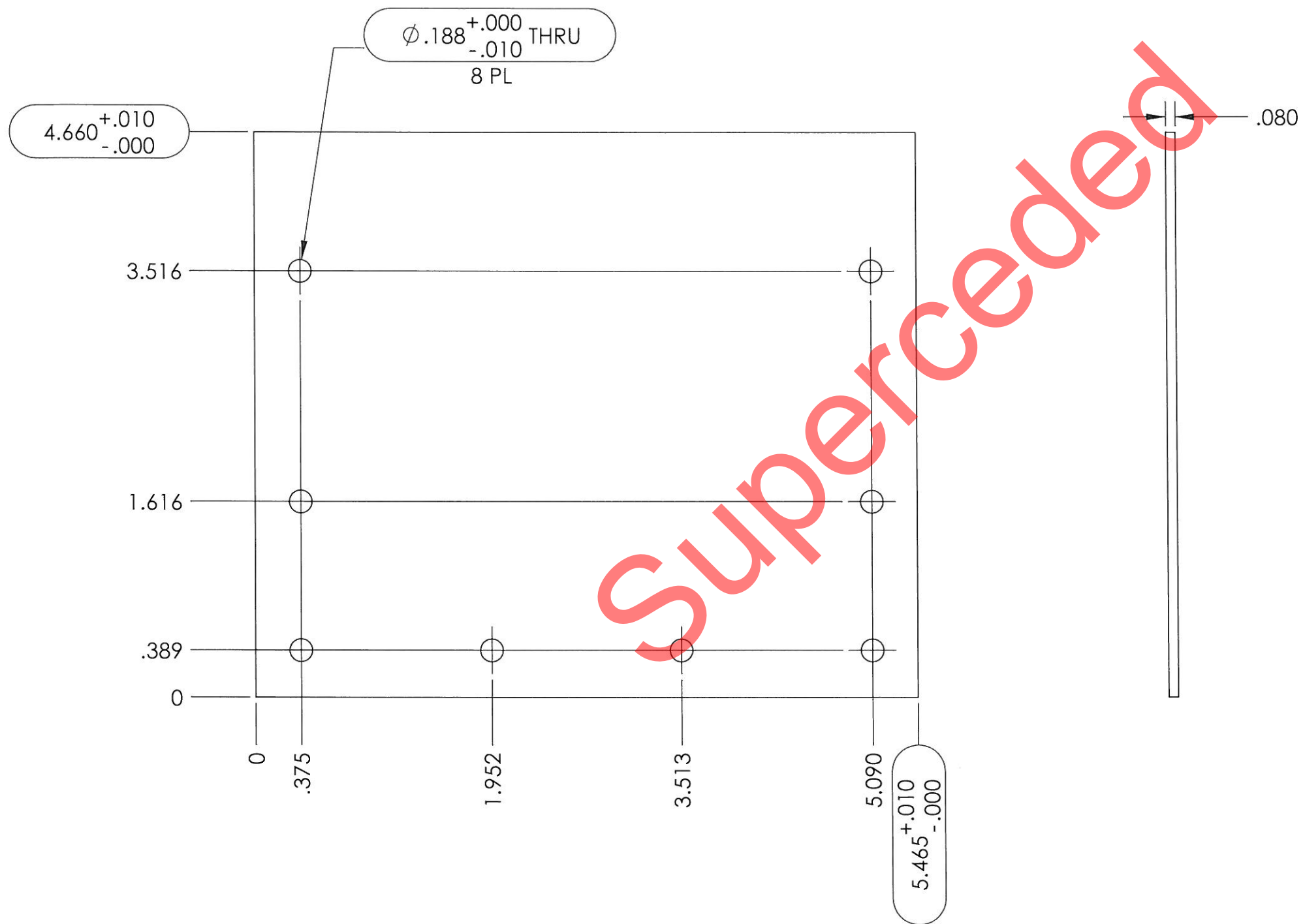
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

A

B

C

D



ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES	
DRAWN BY R. ROSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKER P. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO		SCALE NONE	
CONTRACT No.		SHEET 5 OF 9	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	REV. N/C
		CAGE CODE 07MZ6	DWG. NO. 647.9000

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

647.9016



1.247^{+.010}
- .000

16.800^{+.010}
- .000

2.365^{+.010}
- .000

17.017

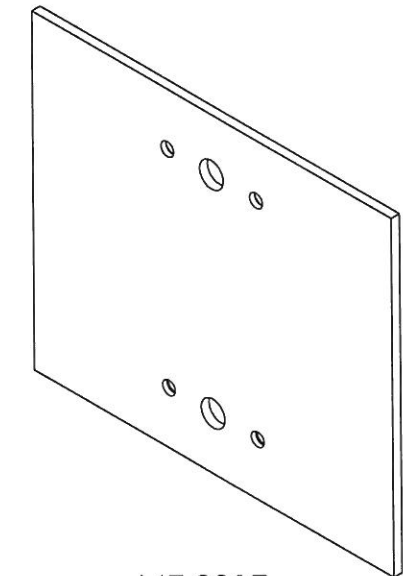
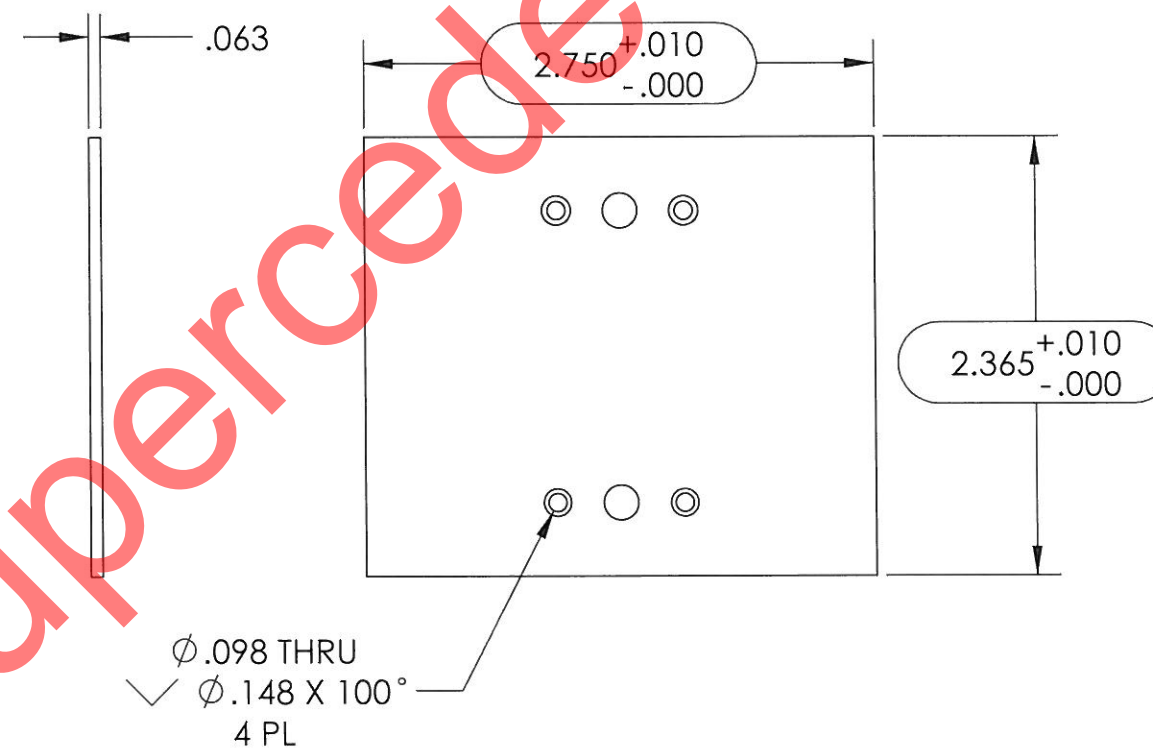
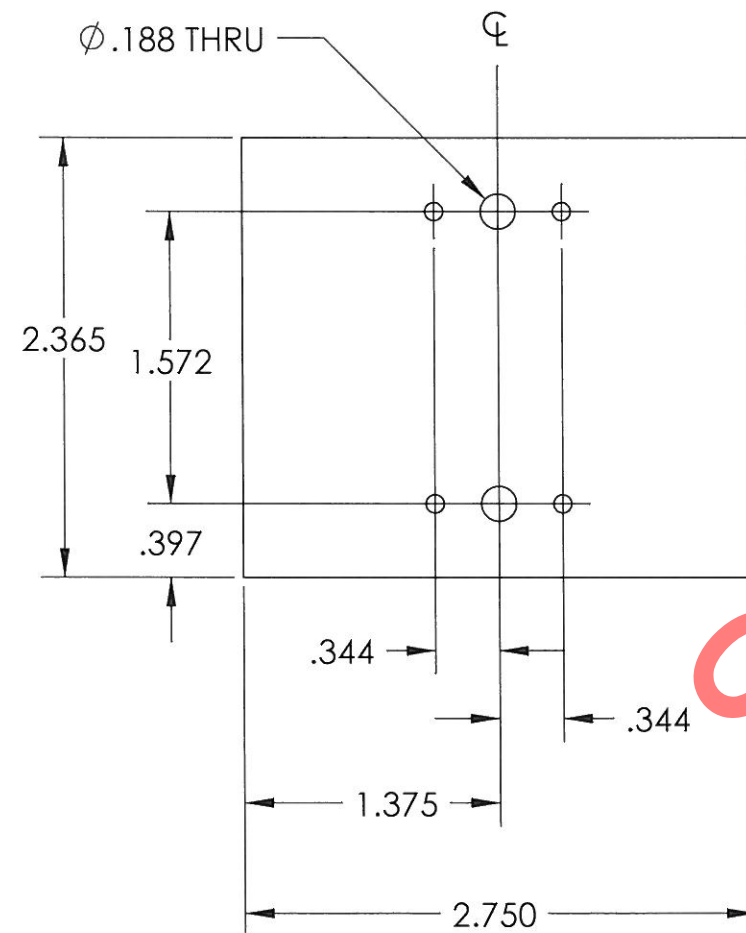
.080

FLAT PATTERN

ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 04-30-10		SHEETMETAL	
CONTRACT No.		SIZE B	REV N/C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07MZ6	DWG. NO. 647.9000
		SCALE NONE	SHEET 6 OF 9

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.9017

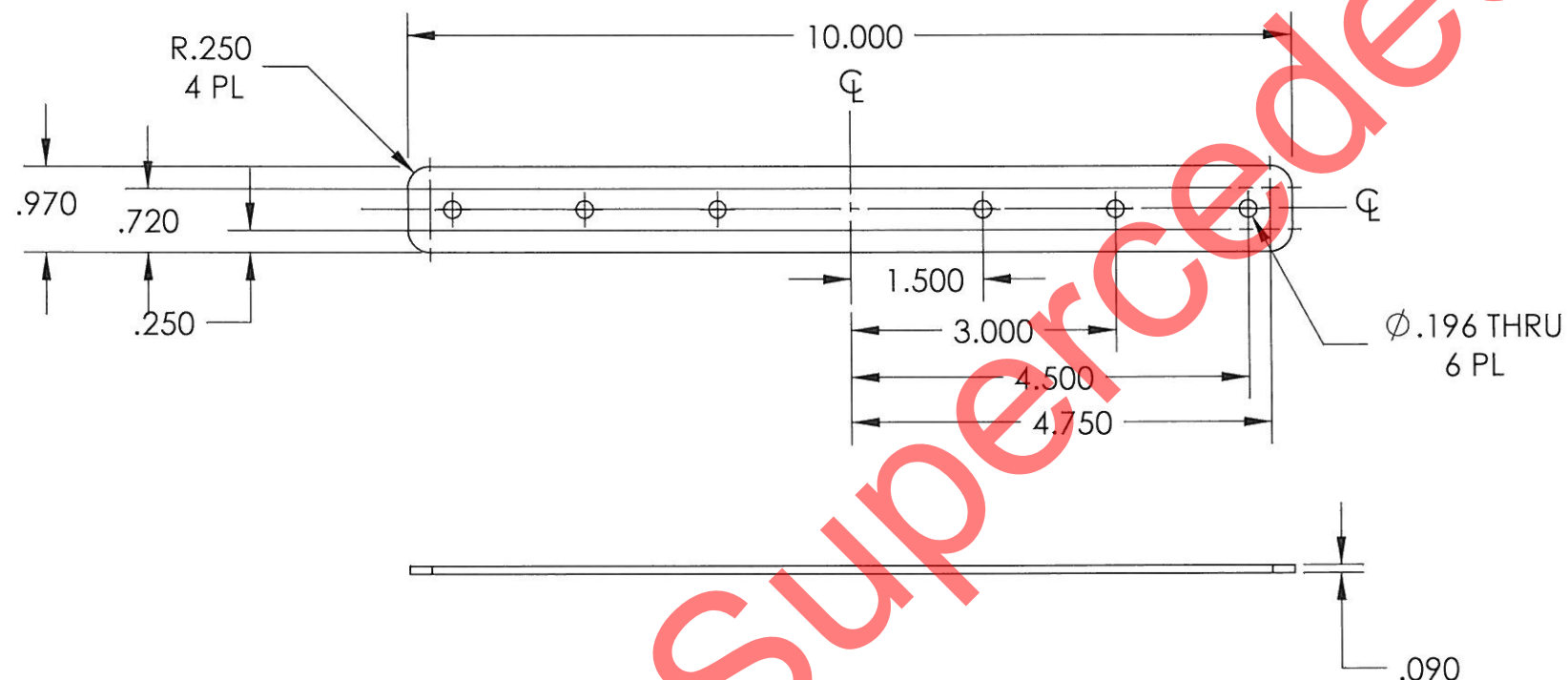
ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 06-30-10		SHEETMETAL	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	REV. N/C
CAGE CODE 07MZ6		DWG. NO. 647.9000	
SCALE NONE		SHEET 7 OF 9	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

PR2

647.9018

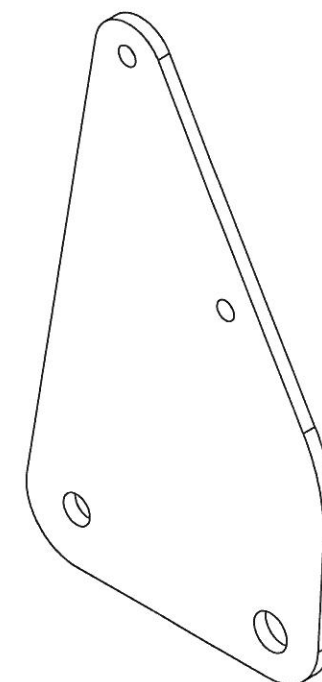
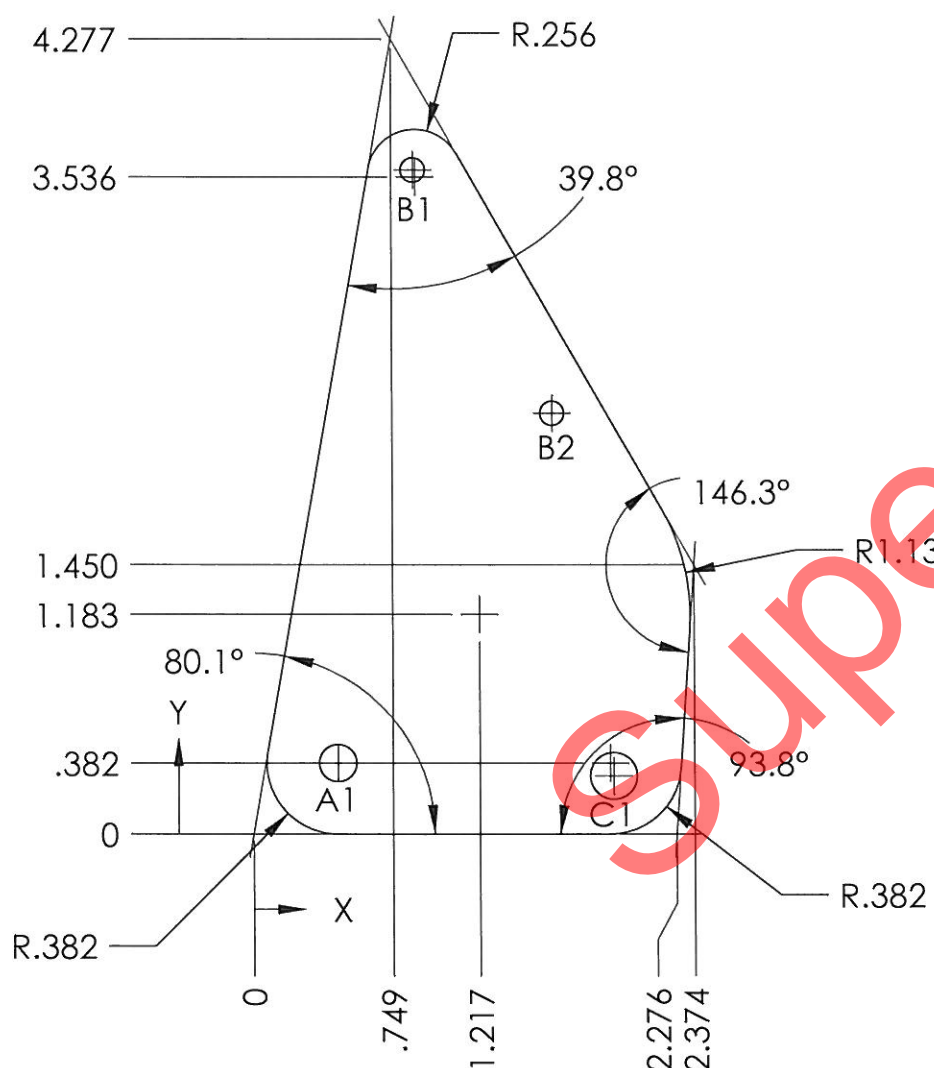


ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 06-30-10		SHEETMETAL	
CONTRACT No.		SIZE B	REV. N/C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		CAGE CODE 07MZ6	DWG. NO. 647.9000
		SCALE NONE	SHEET 8 OF 9

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

PR2



647.9019

TAG	X LOC	Y LOC	SIZE
A1	.455	.382	Ø .201 THRU
B1	.867	3.573	Ø .130 THRU
B2	1.614	2.266	Ø .130 THRU
C1	1.939	.312	Ø .250 THRU

ORIGINAL DATE (MO-DA-YR) 04-13-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 06-30-10		SHEETMETAL	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	REV. N/C
CAGE CODE 07MZ6		DWG. NO. 647.9000	
SCALE NONE		SHEET 9 OF 9	